

**Work Order ID 117805**

Tuesday, May 06, 2014 11:18:56 AM

**\*117805\***

Page 1

Item ID: D3552-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door Prop

Start Date: 5/5/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/6/2014 Req'd Qty: 1.00 **\*1\***

Customer: CHCRA02

Reference: RMA RA111746

Approvals: Process Plan: mf Date: 14-5-6

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3552	K
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100

0.00

**\*100\***

QC

Quality Control

**Memo**INSPECT RA111746  
D3552-11 X 1 B114342

PART IS SCRAP

DISCARD

0.00

DAS  
16  
9-89

14/05/09

①

110

QC21- Final Inspection - Work Order Release

0.00

**\*110\***

QC

Quality Control

**Memo**

0.00



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Tuesday, May 06, 2014 11:18:56 AM

Page 1

Work Order ID: 117805

**\*117805\***

Parent Item: D3552-11

**\*D3552-11\***

Parent Item Name: Door Prop

Start Date: 5/5/2014

Required Date: 5/6/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC IPP Rev:C  
as per dwg RevE DD 10.02.17 verified by:EC IPP Rev:D 10.12.03 as  
per dwg rev.G DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-11		Manufactured	No				Each	8.0000		1			
<b>*D3552-11*</b>										<b>**</b>			

Door Prop

Location

Loc Qty

Loc Code

FG

4

80345

2

96447

2

ST260

4

114342

4

MF 14-5-6

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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# **RA111746 D3552-11 B114342**

RECEIVED APRIL 31, 2014  
INSPECTED MAY 1, 2014

CUSTOMER: HELICRAFT AVIATION LTD  
CONTACT: JOEY NICHOLS  
SHIPPED: OKOTOKS, AL, CANADA

## **Instructions for RA111746 D3552-11 B114342**

- Part is scrap
  - Tension to retract is over tolerance as per dwg
  - We found that the cylinder is bend
- Work order need to scrap part

**Time Estimate** = 1 HOURS

**Departments Required:** small fab

**Pictures Attached** = N/A

**QTY INSPECTED** = x1 D3552-11 B114342

**THIS INSTRUCTION SHEET MUST  
BE ATTACHED TO THE  
RESTOCKING WORK ORDER AT  
ALL TIMES!!!!**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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**DART**  
AEROSPACE

P/N: D 3552-11  
B113883

W/O: \_\_\_\_\_

DWG: \_\_\_\_\_

INS: DAS  
27 MAR 05 2011

**DART**  
AEROSPACE

P/N: D3552-11

W/O: B114342

DWG: Rev 12

INS: MAR 13 2014

D3552-11  
B114342  
RA111746

MAR 01 2014

# **HELICRAFT AVIATION LTD.**

P.O. BOX 85, OKOTOKS, ALBERTA T1S 1A4 . (403) 938-1855

D.O.T. APPROVAL # AMO 62-03

NOMECLATURE DOOR STRUT

PART NO. D 3552-11 S/N \_\_\_\_\_

REASON FOR REMOVAL SEE REVERSE

TO BE: O/H \_\_\_\_\_ REPAIRED \_\_\_\_\_ INSP. \_\_\_\_\_ SCRAP \_\_\_\_\_

TOTAL TIME: 0.0 HRS

TIME SINCE OVERHAUL \_\_\_\_\_

REMOVED FROM AIRCRAFT N/A

DATE 28 APRIL 2014

[Signature]  
INSPECTOR'S SIGNATURE

**UNSERVICEABLE TAG**